

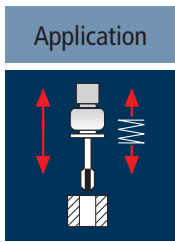
Metric fine thread MF

Tolerance ISO 2 (6H)



	HSS PM/F		Rm 850-1100		247
	HSS PM/F		Rm 850-1100		251
	HM MG10		HRC 48- >60		255
	HSS PM/F		Inox Stainless		257
	HSS PM/F		Inox Stainless		261
	HSS PM/F		GG(G) Cast iron		265
	HSS PM/F		Rm <850-1100	Inox Stainless	269

MF



Material
Steel 500 - 850 N/mm ²
Steel 500 - 850 N/mm ²
Steel 850 - 1100 N/mm ²
Steel 850 - 1100 N/mm ²

MF	ø	P	V _c	n	v _f	V _c	n	v _f	V _c	n	v _f
	[mm]	[mm]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]	3.0 x d	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	25	3185	1115	20	2545	891	15	1910	669
M 3	3.0	0.35	25	2655	929	20	2120	742	15	1590	557
M 3.5	3.5	0.35	25	2275	796	20	1820	637	15	1365	478
M 4	4.0	0.50	25	1990	995	20	1590	795	15	1195	598
M 5	5.0	0.50	25	1590	795	20	1275	638	15	955	478
M 6	6.0	0.50	25	1325	663	20	1060	530	15	795	398
M 8	8.0	0.50	25	995	498	20	795	398	15	595	298
M10	10.0	0.50	25	795	398	20	635	318	15	475	238
M 6	6.0	0.75	25	1325	994	20	1060	795	15	795	596
M 7	7.0	0.75	25	1135	851	20	910	683	15	680	510
M 8	8.0	0.75	25	995	746	20	795	596	15	595	446
M10	10.0	0.75	25	795	596	20	635	476	15	475	356
M 8	8.0	1.00	25	995	995	20	795	795	15	595	595
M 9	9.0	1.00	25	885	885	20	705	705	15	530	530
M10	10.0	1.00	25	795	795	20	635	635	15	475	475
M10	10.0	1.25	25	795	994	20	635	794	15	475	594
M 2.5	2.5	0.35	20	2545	891	15	1910	669	12	1530	536
M 3	3.0	0.35	20	2120	742	15	1590	557	12	1275	446
M 3.5	3.5	0.35	20	1820	637	15	1365	478	12	1090	382
M 4	4.0	0.50	20	1590	795	15	1195	598	12	955	478
M 5	5.0	0.50	20	1275	638	15	955	478	12	765	383
M 6	6.0	0.50	20	1060	530	15	795	398	12	635	318
M 8	8.0	0.50	20	795	398	15	595	298	12	475	238
M10	10.0	0.50	20	635	318	15	475	238	12	380	190
M 6	6.0	0.75	20	1060	795	15	795	596	12	635	476
M 7	7.0	0.75	20	910	683	15	680	510	12	545	409
M 8	8.0	0.75	20	795	596	15	595	446	12	475	356
M10	10.0	0.75	20	635	476	15	475	356	12	380	285
M 8	8.0	1.00	20	795	795	15	595	595	12	475	475
M 9	9.0	1.00	20	705	705	15	530	530	12	425	425
M10	10.0	1.00	20	635	635	15	475	475	12	380	380
M10	10.0	1.25	20	635	794	15	475	594	12	380	475

Material
Steel 1100 - 1300 N/mm ²
Steel 1100 - 1300 N/mm ²

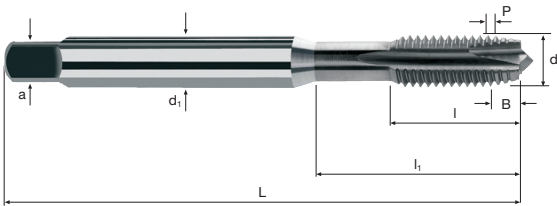
MF	ø	P	V _c	n	v _f	V _c	n	v _f	
	[mm]	[mm]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]	
M 2.5	2.5	0.35	7	890	312	4	510	179	
M 3	3.0	0.35	7	745	261	4	425	149	
M 3.5	3.5	0.35	7	635	222	4	365	128	
M 4	4.0	0.50	7	555	278	4	320	160	
M 5	5.0	0.50	7	445	223	4	255	128	
M 6	6.0	0.50	7	370	185	4	210	105	
M 8	8.0	0.50	7	280	140	4	160	80	
M10	10.0	0.50	7	225	113	4	125	63	
M 6	6.0	0.75	7	370	278	4	210	158	
M 7	7.0	0.75	7	320	240	4	180	135	
M 8	8.0	0.75	7	280	210	4	160	120	
M10	10.0	0.75	7	225	169	4	125	94	
M 8	8.0	1.00	7	280	280	4	160	160	
M 9	9.0	1.00	7	250	250	4	140	140	
M10	10.0	1.00	7	225	225	4	125	125	
M10	10.0	1.25	7	225	281	4	125	156	

MF

ISO 2
(6H)

HSS
PM/F

Form B



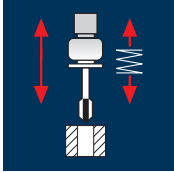
MF

Rm < 850	Rm 850-1100	Rm 1100-1300							
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Example: Order-Nº. Article-Nº. EH1257 α-Code .029										TiCN	
										EH1257	
Ø Code	d	P	L	l	li	d1	a				
.029	M 2.5	0.35	50	9	—	2.8	2.1	2	2.15		●
.031	M 3	0.35	56	12	18	3.5	2.7	3	2.65		●
.032	M 3.5	0.35	56	12	20	4.0	3.0	3	3.15		●
.046	M 4	0.50	63	13	21	4.5	3.4	3	3.50		●
.048	M 5	0.50	70	15	25	6.0	4.9	3	4.50		●
.050	M 6	0.50	80	17	30	6.0	4.9	3	5.50		●
.052	M 8	0.50	90	20	35	8.0	6.2	3	7.50		●
.054	M10	0.50	100	22	39	10.0	8.0	3	9.50		●
.064	M 6	0.75	80	17	30	6.0	4.9	3	5.20		●
.065	M 7	0.75	80	17	30	7.0	5.5	3	6.20		●
.066	M 8	0.75	90	20	35	8.0	6.2	3	7.20		●
.068	M10	0.75	100	22	39	10.0	8.0	3	9.20		●
.090	M 8	1.00	90	20	35	8.0	6.2	3	7.00		●
.091	M 9	1.00	90	20	35	9.0	7.0	3	8.00		●
.092	M10	1.00	100	22	39	10.0	8.0	3	9.00		●
.162	M10	1.25	100	22	39	10.0	8.0	3	8.80		●
For larger dimensions see article no. EH1258, page 249											

Application

The diagram illustrates a mechanical system. A mass, represented by a grey rectangle, is connected to a fixed base (hatched rectangle) by a spring and a damper in parallel. The spring is represented by a coiled line, and the damper is represented by a piston in a cylinder. Red arrows indicate the displacement of the mass from its equilibrium position.



Material

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

MF	ø [mm]	P [mm]	V _c			n			V _c			n			V _c		
			1.5 x d	n [min ⁻¹]	v _f [100%]	2.0 x d	n [min ⁻¹]	v _f [100%]	3.0 x d	n [min ⁻¹]	v _f [100%]						
M12	12.0	0.75	25	665	499	20	530	398	15	400	300						
M14	14.0	0.75	25	570	428	20	455	341	15	340	255						
M16	16.0	0.75	25	495	371	20	400	300	15	300	225						
M12	12.0	1.00	25	665	665	20	530	530	15	400	400						
M13	13.0	1.00	25	610	610	20	490	490	15	365	365						
M14	14.0	1.00	25	570	570	20	455	455	15	340	340						
M16	16.0	1.00	25	495	495	20	400	400	15	300	300						
M18	18.0	1.00	25	440	440	20	355	355	15	265	265						
M20	20.0	1.00	25	400	400	20	320	320	15	240	240						
M12	12.0	1.25	25	665	831	20	530	663	15	400	500						
M14	14.0	1.25	25	570	713	20	455	569	15	340	425						
M16	16.0	1.25	25	495	619	20	400	500	15	300	375						
M12	12.0	1.50	25	665	998	20	530	795	15	400	600						
M14	14.0	1.50	25	570	855	20	455	683	15	340	510						
M16	16.0	1.50	25	495	743	20	400	600	15	300	450						
M18	18.0	1.50	25	440	660	20	355	533	15	265	398						
M20	20.0	1.50	25	400	600	20	320	480	15	240	360						
M24	24.0	1.50	25	330	495	20	265	398	15	200	300						
M12	12.0	0.75	20	530	398	15	400	300	12	320	240						
M14	14.0	0.75	20	455	341	15	340	255	12	275	206						
M16	16.0	0.75	20	400	300	15	300	225	12	240	180						
M12	12.0	1.00	20	530	530	15	400	400	12	320	320						
M13	13.0	1.00	20	490	490	15	365	365	12	295	295						
M14	14.0	1.00	20	455	455	15	340	340	12	275	275						
M16	16.0	1.00	20	400	400	15	300	300	12	240	240						
M18	18.0	1.00	20	355	355	15	265	265	12	210	210						
M20	20.0	1.00	20	320	320	15	240	240	12	190	190						
M12	12.0	1.25	20	530	663	15	400	500	12	320	400						
M14	14.0	1.25	20	455	569	15	340	425	12	275	344						
M16	16.0	1.25	20	400	500	15	300	375	12	240	300						
M12	12.0	1.50	20	530	795	15	400	600	12	320	480						
M14	14.0	1.50	20	455	683	15	340	510	12	275	413						
M16	16.0	1.50	20	400	600	15	300	450	12	240	360						
M18	18.0	1.50	20	355	533	15	265	398	12	210	315						
M20	20.0	1.50	20	320	480	15	240	360	12	190	285						
M24	24.0	1.50	20	265	398	15	200	300	12	160	240						

Material
Steel
1100 - 1300 N/mm²



Steel
1100 - 1300 N/mm²

[illegible]

Taps x-tap

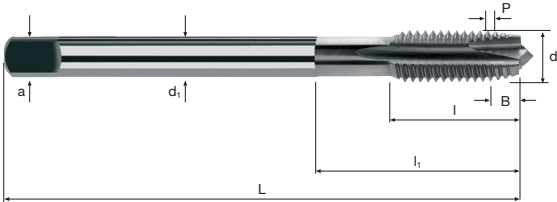


MF

ISO 2
(6H)

HSS
PM/F

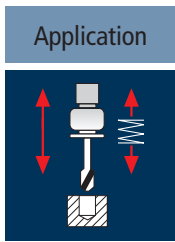
Form B



MF

Rm < 850	Rm 850-1100	Rm 1100-1300							
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Example: Order-Nº.										TiCN	
Article-Nº. α-Code										EH1258	
.070 .070											
Ø Code	d	P	L	l	l ₁	d ₁	a				
.070	M12	0.75	100	18	39	9.0	7.0	3	11.30		●
.072	M14	0.75	100	18	39	11.0	9.0	3	13.30		●
.074	M16	0.75	100	18	39	12.0	9.0	3	15.30		●
.094	M12	1.00	100	18	39	9.0	7.0	3	11.00		●
.095	M13	1.00	100	18	39	11.0	7.0	3	12.00		●
.096	M14	1.00	100	18	39	11.0	9.0	3	13.00		●
.097	M15	1.00	100	18	39	12.0	9.0	3	14.00		●
.098	M16	1.00	100	18	39	12.0	9.0	3	15.00		●
.099	M17	1.00	100	18	39	12.0	9.0	4	16.00		●
.100	M18	1.00	110	20	45	14.0	11.0	4	17.00		●
.102	M20	1.00	125	20	50	16.0	12.0	4	19.00		●
.164	M12	1.25	100	22	39	9.0	7.0	3	10.80		●
.166	M14	1.25	100	22	39	11.0	9.0	3	12.80		●
.168	M16	1.25	100	22	39	12.0	9.0	3	14.80		●
.176	M12	1.50	100	22	39	9.0	7.0	3	10.50		●
.178	M14	1.50	100	22	39	11.0	9.0	3	12.50		●
.180	M16	1.50	100	22	39	12.0	9.0	3	14.50		●
.182	M18	1.50	110	22	45	14.0	11.0	4	16.50		●
.184	M20	1.50	125	25	50	16.0	12.0	4	18.50		●
.186	M22	1.50	125	26	50	18.0	14.5	4	20.50		●
.188	M24	1.50	140	27	52	18.0	14.5	4	22.50		●



Material
Steel 500 - 850 N/mm ²
Steel 500 - 850 N/mm ²
Steel 850 - 1100 N/mm ²
Steel 850 - 1100 N/mm ²

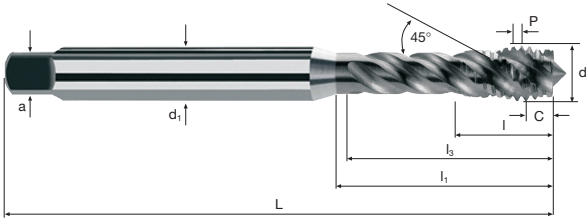
MF	ø	P	v_c	n	v_f	v_c	n	v_f	v_c	n	v_f
	[mm]	[mm]	$1.0 \times d$	[min ⁻¹]	[100%]	$1.5 \times d$	[min ⁻¹]	[100%]	$2.0 \times d$	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	32	4075	1426	28	3565	1248	22	2800	980
M 3	3.0	0.35	32	3395	1188	28	2970	1040	22	2335	817
M 3.5	3.5	0.35	32	2910	1018	28	2545	891	22	2000	700
M 4	4.0	0.50	32	2545	1273	28	2230	1115	22	1750	875
M 5	5.0	0.50	32	2035	1018	28	1785	893	22	1400	700
M 6	6.0	0.50	32	1700	850	28	1485	743	22	1165	583
M 8	8.0	0.50	32	1275	638	28	1115	558	22	875	438
M10	10.0	0.50	32	1020	510	28	890	445	22	700	350
M 6	6.0	0.75	32	1700	1275	28	1485	1114	22	1165	874
M 7	7.0	0.75	32	1455	1091	28	1275	956	22	1000	750
M 8	8.0	0.75	32	1275	956	28	1115	836	22	875	656
M10	10.0	0.75	32	1020	765	28	890	668	22	700	525
M 8	8.0	1.00	32	1275	1275	28	1115	1115	22	875	875
M 9	9.0	1.00	32	1130	1130	28	990	990	22	780	780
M10	10.0	1.00	32	1020	1020	28	890	890	22	700	700
M10	10.0	1.25	32	1020	1275	28	890	1113	22	700	875
M 2.5	2.5	0.35	20	2545	891	16	2035	712	10	1275	446
M 3	3.0	0.35	20	2120	742	16	1700	595	10	1060	371
M 3.5	3.5	0.35	20	1820	637	16	1455	509	10	910	319
M 4	4.0	0.50	20	1590	795	16	1275	638	10	795	398
M 5	5.0	0.50	20	1275	638	16	1020	510	10	635	318
M 6	6.0	0.50	20	1060	530	16	850	425	10	530	265
M 8	8.0	0.50	20	795	398	16	635	318	10	400	200
M10	10.0	0.50	20	635	318	16	510	255	10	320	160
M 6	6.0	0.75	20	1060	795	16	850	638	10	530	398
M 7	7.0	0.75	20	910	683	16	730	548	10	455	341
M 8	8.0	0.75	20	795	596	16	635	476	10	400	300
M10	10.0	0.75	20	635	476	16	510	383	10	320	240
M 8	8.0	1.00	20	795	795	16	635	635	10	400	400
M 9	9.0	1.00	20	705	705	16	565	565	10	355	355
M10	10.0	1.00	20	635	635	16	510	510	10	320	320
M10	10.0	1.25	20	635	794	16	510	638	10	320	400

MF

ISO 2
(6H)

HSS
PM/F

Form C



MF

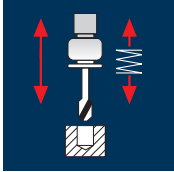
Rm < 850	Rm 850-1100									
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Example: Order-Nº.											TiCN	
Article-Nº. α-Code											EH1260 .029	
Ø Code	d	P	L	l	l1	l3	d1	a				
.029	M 2.5	0.35	50	9	—	13	2.8	2.1	3	2.15		●
.031	M 3	0.35	56	5	18	16	3.5	2.7	3	2.65		●
.032	M 3.5	0.35	56	6	20	18	4.0	3.0	3	3.15		●
.046	M 4	0.50	63	7	21	19	4.5	3.4	3	3.50		●
.048	M 5	0.50	70	8	25	23	6.0	4.9	3	4.50		●
.050	M 6	0.50	80	10	30	28	6.0	4.9	3	5.50		●
.052	M 8	0.50	90	13	35	33	8.0	6.2	3	7.50		●
.054	M10	0.50	100	15	39	37	10.0	8.0	4	9.50		●
.064	M 6	0.75	80	10	30	28	6.0	4.9	3	5.20		●
.065	M 7	0.75	80	10	30	28	7.0	5.5	3	6.20		●
.066	M 8	0.75	90	13	35	33	8.0	6.2	3	7.20		●
.068	M10	0.75	100	15	39	37	10.0	8.0	4	9.20		●
.090	M 8	1.00	90	13	35	33	8.0	6.2	3	7.00		●
.091	M 9	1.00	90	13	35	33	9.0	7.0	3	8.00		●
.092	M10	1.00	100	15	39	37	10.0	8.0	4	9.00		●
.162	M10	1.25	100	15	39	37	10.0	8.0	4	8.80		●
For larger dimensions see article no. EH1261, page 253												

Application



The diagram shows a mechanical assembly. A central vertical shaft passes through a block at the bottom. A piston is mounted on the shaft, and a spring is attached to the top of the piston. Red arrows indicate the direction of movement: a double-headed arrow on the left and a single-headed arrow pointing up on the right, suggesting the spring's function is to push the piston upwards.



Material

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Material

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

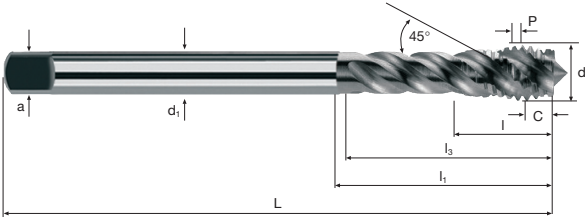
[illegible][illegible]

MF

ISO 2
(6H)

HSS
PM/F

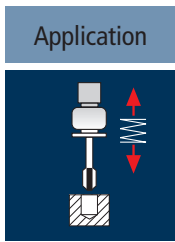
Form C



MF

Rm < 850	Rm 850-1100									
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Example: Order-Nº.											TiCN	
Article-Nº. α-Code											EH1261	
.070												
Ø Code	d	P	L	l	l1	l3	d1	a				
.070	M12	0.75	100	11	39	37	9.0	7.0	4	11.30		●
.072	M14	0.75	100	11	39	37	11.0	9.0	4	13.30		●
.074	M16	0.75	100	12	39	37	12.0	9.0	4	15.30		●
.094	M12	1.00	100	11	39	37	9.0	7.0	4	11.00		●
.095	M13	1.00	100	11	39	37	11.0	9.0	4	12.00		●
.096	M14	1.00	100	11	39	37	11.0	9.0	4	13.00		●
.097	M15	1.00	100	12	39	37	12.0	9.0	4	14.00		●
.098	M16	1.00	100	12	39	37	12.0	9.0	4	15.00		●
.099	M17	1.00	100	12	39	37	12.0	9.0	4	16.00		●
.100	M18	1.00	110	13	50	48	14.0	11.0	4	17.00		●
.102	M20	1.00	125	14	65	63	16.0	12.0	4	19.00		●
.164	M12	1.25	100	15	39	37	9.0	7.0	4	10.80		●
.166	M14	1.25	100	15	39	37	11.0	9.0	4	12.80		●
.168	M16	1.25	100	15	39	37	12.0	9.0	4	14.80		●
.176	M12	1.50	100	15	39	37	9.0	7.0	4	10.50		●
.178	M14	1.50	100	15	39	37	11.0	9.0	4	12.50		●
.180	M16	1.50	100	15	39	37	12.0	9.0	4	14.50		●
.182	M18	1.50	110	17	50	48	14.0	11.0	4	16.50		●
.184	M20	1.50	125	18	65	63	16.0	12.0	4	18.50		●
.186	M22	1.50	125	18	65	63	18.0	14.5	5	20.50		●
.188	M24	1.50	140	20	72	70	18.0	14.5	5	22.50		●



Material

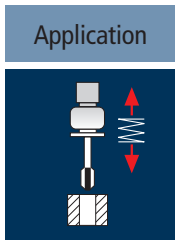
Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

Hardened tool steel
> 60 HRC

MF	ø [mm]	P [mm]	V _c 1.0 x d			V _c 1.5 x d			V _c 2.0 x d		
			n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]	
M 6	6.0	0.50	8	425	213	6	320	160	4	210	105
M 8	8.0	1.00	8	320	320	6	240	240	4	160	160
M10	10.0	1.00	8	255	255	6	190	190	4	125	125
M12	12.0	1.50	8	210	315	6	160	240	4	105	158
M14	14.0	1.50	8	180	270	6	135	203	4	90	135
M16	16.0	1.50	8	160	240	6	120	180	4	80	120
M 6	6.0	0.50	6	320	160	4	210	105	3	160	80
M 8	8.0	1.00	6	240	240	4	160	160	3	120	120
M10	10.0	1.00	6	190	190	4	125	125	3	95	95
M12	12.0	1.50	6	160	240	4	105	158	3	80	120
M14	14.0	1.50	6	135	203	4	90	135	3	70	105
M16	16.0	1.50	6	120	180	4	80	120	3	60	90
M 6	6.0	0.50	4	210	105	2	105	53			
M 8	8.0	1.00	4	160	160	2	80	80			
M10	10.0	1.00	4	125	125	2	65	65			
M12	12.0	1.50	4	105	158	2	55	83			
M14	14.0	1.50	4	90	135	2	45	68			
M16	16.0	1.50	4	80	120	2	40	60			
M 6	6.0	0.50	2	105	53	1.5	80	40			
M 8	8.0	1.00	2	80	80	1.5	60	60			
M10	10.0	1.00	2	65	65	1.5	50	50			
M12	12.0	1.50	2	55	83	1.5	40	60			
M14	14.0	1.50	2	45	68	1.5	35	53			
M16	16.0	1.50	2	40	60	1.5	30	45			



Material

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

Hardened tool steel
> 60 HRC

MF	ø [mm]	P [mm]	V _c 1.5 x d			V _c 2.0 x d			V _c 3.0 x d		
			n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]	
M 6	6.0	0.50	8	425	213	6	320	160	4	210	105
M 8	8.0	1.00	8	320	320	6	240	240	4	160	160
M10	10.0	1.00	8	255	255	6	190	190	4	125	125
M12	12.0	1.50	8	210	315	6	160	240	4	105	158
M14	14.0	1.50	8	180	270	6	135	203	4	90	135
M16	16.0	1.50	8	160	240	6	120	180	4	80	120
M 6	6.0	0.50	6	320	160	4	210	105	3	160	80
M 8	8.0	1.00	6	240	240	4	160	160	3	120	120
M10	10.0	1.00	6	190	190	4	125	125	3	95	95
M12	12.0	1.50	6	160	240	4	105	158	3	80	120
M14	14.0	1.50	6	135	203	4	90	135	3	70	105
M16	16.0	1.50	6	120	180	4	80	120	3	60	90
M 6	6.0	0.50	4	210	105	2	105	53			
M 8	8.0	1.00	4	160	160	2	80	80			
M10	10.0	1.00	4	125	125	2	65	65			
M12	12.0	1.50	4	105	158	2	55	83			
M14	14.0	1.50	4	90	135	2	45	68			
M16	16.0	1.50	4	80	120	2	40	60			
M 6	6.0	0.50	2	105	53	1.5	80	40			
M 8	8.0	1.00	2	80	80	1.5	60	60			
M10	10.0	1.00	2	65	65	1.5	50	50			
M12	12.0	1.50	2	55	83	1.5	40	60			
M14	14.0	1.50	2	45	68	1.5	35	53			
M16	16.0	1.50	2	40	60	1.5	30	45			

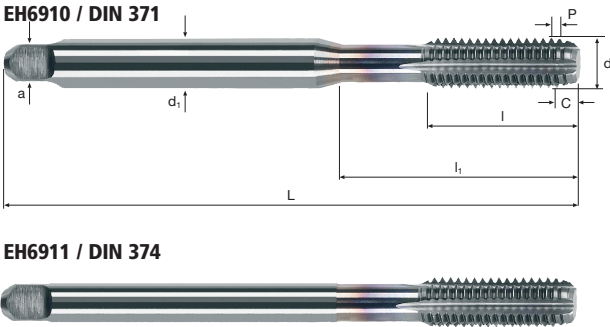
MF

ISO 2
(6H)

HM
MG10

DIN
371/374

X · P
Form C

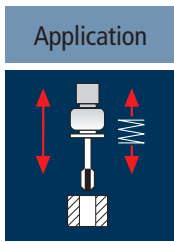


MF

				HRC 48-56	HRC 56-60	HRC > 60			
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Example: Order-N°.										TiCN	
Article-N°.										EH6910	
ø Code											
d P L l l1 d1 a											
.050	M 6	0.50	80	17	30	6.0	4.9	4	5.60 *		●
.090	M 8	1.00	90	20	35	8.0	6.2	5	7.10		●
.092	M10	1.00	100	22	39	10.0	8.0	5	9.10		●

Example: Order-N°.										TiCN	
Article-N°.										EH6911	
ø Code											
d P L l l1 d1 a											
.176	M12	1.50	100	22	39	9	7.0	5	10.70 *		●
.178	M14	1.50	100	22	39	11	9.0	5	12.70 *		●
.180	M16	1.50	100	22	39	12	9.0	5	14.70 *		●
* The given dimension is out of norm											



Material	
Stainless steel ferritic/martensitic	
Stainless steel ferritic/martensitic	
Stainless steel [Cr-Ni/1.4301]	
Stainless steel [Cr-Ni/1.4301]	

MF	ø [mm]	P [mm]	V _c 1.5 x d			V _c 2.0 x d			V _c 3.0 x d		
			n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]	
M 2.5	2.5	0.35	12	1530	536	10	1275	446	8	1020	357
M 3	3.0	0.35	12	1275	446	10	1060	371	8	850	298
M 3.5	3.5	0.35	12	1090	382	10	910	319	8	730	255
M 4	4.0	0.50	12	955	478	10	795	398	8	635	318
M 5	5.0	0.50	12	765	383	10	635	318	8	510	255
M 6	6.0	0.50	12	635	318	10	530	265	8	425	213
M 8	8.0	0.50	12	475	238	10	400	200	8	320	160
M10	10.0	0.50	12	380	190	10	320	160	8	255	128
M 6	6.0	0.75	12	635	476	10	530	398	8	425	319
M 7	7.0	0.75	12	545	409	10	455	341	8	365	274
M 8	8.0	0.75	12	475	356	10	400	300	8	320	240
M10	10.0	0.75	12	380	285	10	320	240	8	255	191
M 8	8.0	1.00	12	475	475	10	400	400	8	320	320
M 9	9.0	1.00	12	425	425	10	355	355	8	285	285
M10	10.0	1.00	12	380	380	10	320	320	8	255	255
M10	10.0	1.25	12	380	475	10	320	400	8	255	319
M 2.5	2.5	0.35	7	890	312	5	635	222	4	510	179
M 3	3.0	0.35	7	745	261	5	530	186	4	425	149
M 3.5	3.5	0.35	7	635	222	5	455	159	4	365	128
M 4	4.0	0.50	7	555	278	5	400	200	4	320	160
M 5	5.0	0.50	7	445	223	5	320	160	4	255	128
M 6	6.0	0.50	7	370	185	5	265	133	4	210	105
M 8	8.0	0.50	7	280	140	5	200	100	4	160	80
M10	10.0	0.50	7	225	113	5	160	80	4	125	63
M 6	6.0	0.75	7	370	278	5	265	199	4	210	158
M 7	7.0	0.75	7	320	240	5	225	169	4	180	135
M 8	8.0	0.75	7	280	210	5	200	150	4	160	120
M10	10.0	0.75	7	225	169	5	160	120	4	125	94
M 8	8.0	1.00	7	280	280	5	200	200	4	160	160
M 9	9.0	1.00	7	250	250	5	175	175	4	140	140
M10	10.0	1.00	7	225	225	5	160	160	4	125	125
M10	10.0	1.25	7	225	281	5	160	200	4	125	156

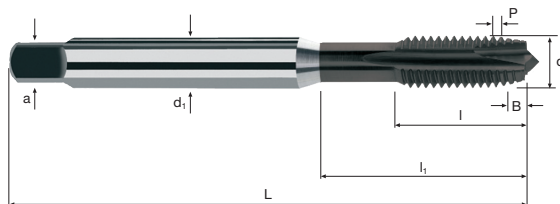
Material	
Stainless steel [Cr-Ni-Mo-.../1.4571]	
Stainless steel [Cr-Ni-Mo-.../1.4571]	
Heat resistant steel [17-4 PH]	
Heat resistant steel [17-4 PH]	

MF	ø [mm]	P [mm]	V _c 1.5 x d			V _c 2.0 x d			V _c 3.0 x d		
			n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]		n [min ⁻¹]	v _f [100%]	
M 2.5	2.5	0.35	8	1020	357	6	765	268	5	635	222
M 3	3.0	0.35	8	850	298	6	635	222	5	530	186
M 3.5	3.5	0.35	8	730	255	6	545	191	5	455	159
M 4	4.0	0.50	8	635	318	6	475	238	5	400	200
M 5	5.0	0.50	8	510	255	6	380	190	5	320	160
M 6	6.0	0.50	8	425	213	6	320	160	5	265	133
M 8	8.0	0.50	8	320	160	6	240	120	5	200	100
M10	10.0	0.50	8	255	128	6	190	95	5	160	80
M 6	6.0	0.75	8	425	319	6	320	240	5	265	199
M 7	7.0	0.75	8	365	274	6	275	206	5	225	169
M 8	8.0	0.75	8	320	240	6	240	180	5	200	150
M10	10.0	0.75	8	255	191	6	190	143	5	160	120
M 8	8.0	1.00	8	320	320	6	240	240	5	200	200
M 9	9.0	1.00	8	285	285	6	210	210	5	175	175
M10	10.0	1.00	8	255	255	6	190	190	5	160	160
M10	10.0	1.25	8	255	319	6	190	238	5	160	200
M 2.5	2.5	0.35	5	635	222	4	510	179	3	380	133
M 3	3.0	0.35	5	530	186	4	425	149	3	320	112
M 3.5	3.5	0.35	5	455	159	4	365	128	3	275	96
M 4	4.0	0.50	5	400	200	4	320	160	3	240	120
M 5	5.0	0.50	5	320	160	4	255	128	3	190	95
M 6	6.0	0.50	5	265	133	4	210	105	3	160	80
M 8	8.0	0.50	5	200	100	4	160	80	3	120	60
M10	10.0	0.50	5	160	80	4	125	63	3	95	48
M 6	6.0	0.75	5	265	199	4	210	158	3	160	120
M 7	7.0	0.75	5	225	169	4	180	135	3	135	101
M 8	8.0	0.75	5	200	150	4	160	120	3	120	90
M10	10.0	0.75	5	160	120	4	125	94	3	95	71
M 8	8.0	1.00	5	200	200	4	160	160	3	120	120
M 9	9.0	1.00	5	175	175	4	140	140	3	105	105
M10	10.0	1.00	5	160	160	4	125	125	3	95	95
M10	10.0	1.25	5	160	200	4	125	156	3	95	119

ISO 2
(6H)



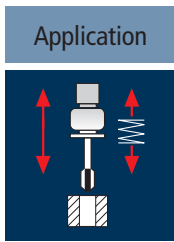
**HSS
PM/F**

DIN
371

MF

Inox
Stainless

257



Material

Stainless steel
ferritic/martensitic

Stainless steel
ferritic/martensitic

Stainless steel
[Cr-Ni/1.4301]

Stainless steel
[Cr-Ni/1.4301]

MF	ø [mm]	P [mm]	V_c n v_f			V_c n v_f			V_c n v_f		
			$1.5 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$	$2.0 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$	$3.0 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$
M12	12.0	0.75	12	320	240	10	265	199	8	210	158
M14	14.0	0.75	12	275	206	10	225	169	8	180	135
M16	16.0	0.75	12	240	180	10	200	150	8	160	120
M12	12.0	1.00	12	320	320	10	265	265	8	210	210
M13	13.0	1.00	12	295	295	10	245	245	8	195	195
M14	14.0	1.00	12	275	275	10	225	225	8	180	180
M16	16.0	1.00	12	240	240	10	200	200	8	160	160
M18	18.0	1.00	12	210	210	10	175	175	8	140	140
M20	20.0	1.00	12	190	190	10	160	160	8	125	125
M12	12.0	1.25	12	320	400	10	265	331	8	210	263
M14	14.0	1.25	12	275	344	10	225	281	8	180	225
M16	16.0	1.25	12	240	300	10	200	250	8	160	200
M12	12.0	1.50	12	320	480	10	265	398	8	210	315
M14	14.0	1.50	12	275	413	10	225	338	8	180	270
M16	16.0	1.50	12	240	360	10	200	300	8	160	240
M18	18.0	1.50	12	210	315	10	175	263	8	140	210
M20	20.0	1.50	12	190	285	10	160	240	8	125	188
M24	24.0	1.50	12	160	240	10	135	203	8	105	158
M12	12.0	0.75	7	185	139	5	135	101	4	105	79
M14	14.0	0.75	7	160	120	5	115	86	4	90	68
M16	16.0	0.75	7	140	105	5	100	75	4	80	60
M12	12.0	1.00	7	185	185	5	135	135	4	105	105
M13	13.0	1.00	7	170	170	5	120	120	4	100	100
M14	14.0	1.00	7	160	160	5	115	115	4	90	90
M16	16.0	1.00	7	140	140	5	100	100	4	80	80
M18	18.0	1.00	7	125	125	5	90	90	4	70	70
M20	20.0	1.00	7	110	110	5	80	80	4	65	65
M12	12.0	1.25	7	185	231	5	135	169	4	105	131
M14	14.0	1.25	7	160	200	5	115	144	4	90	113
M16	16.0	1.25	7	140	175	5	100	125	4	80	100
M12	12.0	1.50	7	185	278	5	135	203	4	105	158
M14	14.0	1.50	7	160	240	5	115	173	4	90	135
M16	16.0	1.50	7	140	210	5	100	150	4	80	120
M18	18.0	1.50	7	125	188	5	90	135	4	70	105
M20	20.0	1.50	7	110	165	5	80	120	4	65	98
M24	24.0	1.50	7	95	143	5	65	98	4	55	83

Material

Stainless steel
[Cr-Ni-Mo-.../1.4571]

Stainless steel
[Cr-Ni-Mo-.../1.4571]

Heat resistant steel
[17-4 PH]

Heat resistant steel
[17-4 PH]

MF	ø [mm]	P [mm]	V_c n v_f			V_c n v_f			V_c n v_f		
			$1.5 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$	$2.0 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$	$3.0 \times d$	$[\text{min}^{-1}]$	$[\text{100\%}]$
M12	12.0	0.75	8	210	158	6	160	120	5	135	101
M14	14.0	0.75	8	180	135	6	135	101	5	115	86
M16	16.0	0.75	8	160	120	6	120	90	5	100	75
M12	12.0	1.00	8	210	210	6	160	160	5	135	135
M13	13.0	1.00	8	195	195	6	145	145	5	120	120
M14	14.0	1.00	8	180	180	6	135	135	5	115	115
M16	16.0	1.00	8	160	160	6	120	120	5	100	100
M18	18.0	1.00	8	140	140	6	105	105	5	90	90
M20	20.0	1.00	8	125	125	6	95	95	5	80	80
M12	12.0	1.25	8	210	263	6	160	200	5	135	169
M14	14.0	1.25	8	180	225	6	135	169	5	115	144
M16	16.0	1.25	8	160	200	6	120	150	5	100	125
M12	12.0	1.50	8	210	315	6	160	240	5	135	203
M14	14.0	1.50	8	180	270	6	135	203	5	115	173
M16	16.0	1.50	8	160	240	6	120	180	5	100	150
M18	18.0	1.50	8	140	210	6	105	158	5	90	135
M20	20.0	1.50	8	125	188	6	95	143	5	80	120
M24	24.0	1.50	8	105	158	6	80	120	5	65	98
M12	12.0	0.75	5	135	101	4	105	79	3	80	60
M14	14.0	0.75	5	115	86	4	90	68	3	70	53
M16	16.0	0.75	5	100	75	4	80	60	3	60	45
M12	12.0	1.00	5	135	135	4	105	105	3	80	80
M13	13.0	1.00	5	120	120	4	100	100	3	75	75
M14	14.0	1.00	5	115	115	4	90	90	3	70	70
M16	16.0	1.00	5	100	100	4	80	80	3	60	60
M18	18.0	1.00	5	90	90	4	70	70	3	55	55
M20	20.0	1.00	5	80	80	4	65	65	3	50	50
M12	12.0	1.25	5	135	169	4	105	131	3	80	100
M14	14.0	1.25	5	115	144	4	90	113	3	70	88
M16	16.0	1.25	5	100	125	4	80	100	3	60	75
M12	12.0	1.50	5	135	203	4	105	158	3	80	120
M14	14.0	1.50	5	115	173	4	90	135	3	70	105
M16	16.0	1.50	5	100	150	4	80	120	3	60	90
M18	18.0	1.50	5	90	135	4	70	105	3	55	83
M20	20.0	1.50	5	80	120	4	65	98	3	50	75
M24	24.0	1.50	5	65	98	4	55	83	3	40	60

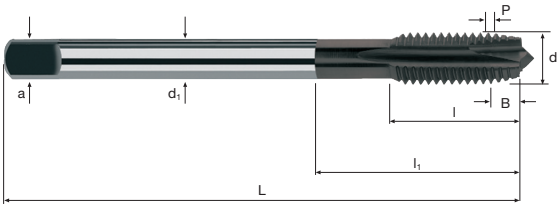


MF

ISO 2
(6H)

HSS
PM/F

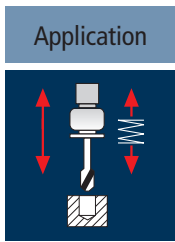
Form B



MF

Inox
Stainless

										TRIBO	
										ET1241	
Example: Order-N°.											
Article-N°.											
α-Code											
ET1241 .070											
Ø Code	d	P	L	l	l ₁	d ₁	a				
.070	M12	0.75	100	18	39	9.0	7.0	3	11.40 *		●
.072	M14	0.75	100	18	39	11.0	9.0	3	13.40 *		●
.074	M16	0.75	100	18	39	12.0	9.0	3	15.40 *		●
.094	M12	1.00	100	18	39	9.0	7.0	3	11.10		●
.095	M13	1.00	100	18	39	11.0	9.0	3	12.10		●
.096	M14	1.00	100	18	39	11.0	9.0	3	13.10		●
.097	M15	1.00	100	18	39	12.0	9.0	3	14.10		●
.098	M16	1.00	100	18	39	12.0	9.0	3	15.10		●
.099	M17	1.00	100	18	39	12.0	9.0	4	16.10		●
.100	M18	1.00	110	20	45	14.0	11.0	4	17.10		●
.102	M20	1.00	125	20	50	16.0	12.0	4	19.10		●
.164	M12	1.25	100	22	39	9.0	7.0	3	10.90		●
.166	M14	1.25	100	22	39	11.0	9.0	3	12.90		●
.168	M16	1.25	100	22	39	12.0	9.0	3	14.90		●
.176	M12	1.50	100	22	39	9.0	7.0	3	10.70		●
.178	M14	1.50	100	22	39	11.0	9.0	3	12.70		●
.180	M16	1.50	100	22	39	12.0	9.0	3	14.70		●
.182	M18	1.50	110	25	45	14.0	11.0	4	16.70		●
.184	M20	1.50	125	26	50	16.0	12.0	4	18.70		●
.186	M22	1.50	125	26	50	18.0	14.5	4	20.70		●
.188	M24	1.50	140	27	52	18.0	14.5	4	22.70		●
* The given dimension is out of norm											



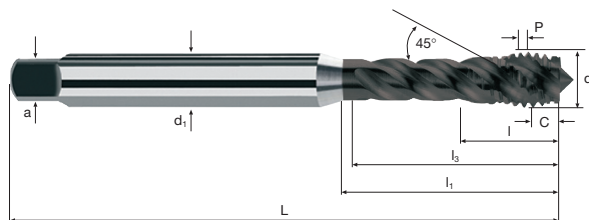
Material
Stainless steel ferritic/martensitic
Stainless steel ferritic/martensitic
Stainless steel [Cr-Ni/1.4301]
Stainless steel [Cr-Ni/1.4301]

MF	ø	P	V _c	n	v _f	V _c	n	v _f	V _c	n	v _f
	[mm]	[mm]	1.0 x d	[min ⁻¹]	[100%]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	10	1275	446	8	1020	357	6	765	268
M 3	3.0	0.35	10	1060	371	8	850	298	6	635	222
M 3.5	3.5	0.35	10	910	319	8	730	255	6	545	191
M 4	4.0	0.50	10	795	398	8	635	318	6	475	238
M 5	5.0	0.50	10	635	318	8	510	255	6	380	190
M 6	6.0	0.50	10	530	265	8	425	213	6	320	160
M 8	8.0	0.50	10	400	200	8	320	160	6	240	120
M10	10.0	0.50	10	320	160	8	255	128	6	190	95
M 6	6.0	0.75	10	530	398	8	425	319	6	320	240
M 7	7.0	0.75	10	455	341	8	365	274	6	275	206
M 8	8.0	0.75	10	400	300	8	320	240	6	240	180
M10	10.0	0.75	10	320	240	8	255	191	6	190	143
M 8	8.0	1.00	10	400	400	8	320	320	6	240	240
M 9	9.0	1.00	10	355	355	8	285	285	6	210	210
M10	10.0	1.00	10	320	320	8	255	255	6	190	190
M10	10.0	1.25	10	320	400	8	255	319	6	190	238
M 2.5	2.5	0.35	5	635	222	4	510	179	3	380	133
M 3	3.0	0.35	5	530	186	4	425	149	3	320	112
M 3.5	3.5	0.35	5	455	159	4	365	128	3	275	96
M 4	4.0	0.50	5	400	200	4	320	160	3	240	120
M 5	5.0	0.50	5	320	160	4	255	128	3	190	95
M 6	6.0	0.50	5	265	133	4	210	105	3	160	80
M 8	8.0	0.50	5	200	100	4	160	80	3	120	60
M10	10.0	0.50	5	160	80	4	125	63	3	95	48
M 6	6.0	0.75	5	265	199	4	210	158	3	160	120
M 7	7.0	0.75	5	225	169	4	180	135	3	135	101
M 8	8.0	0.75	5	200	150	4	160	120	3	120	90
M10	10.0	0.75	5	160	120	4	125	94	3	95	71
M 8	8.0	1.00	5	200	200	4	160	160	3	120	120
M 9	9.0	1.00	5	175	175	4	140	140	3	105	105
M10	10.0	1.00	5	160	160	4	125	125	3	95	95
M10	10.0	1.25	5	160	200	4	125	156	3	95	119

Material
Stainless steel [Cr-Ni-Mo-.../1.4571]
Stainless steel [Cr-Ni-Mo-.../1.4571]
Heat resistant steel [17-4 PH]
Heat resistant steel [17-4 PH]

MF	ø	P	V _c	n	v _f	V _c	n	v _f	V _c	n	v _f
	[mm]	[mm]	1.0 x d	[min ⁻¹]	[100%]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	6	765	268	5	635	222	4	510	179
M 3	3.0	0.35	6	635	222	5	530	186	4	425	149
M 3.5	3.5	0.35	6	545	191	5	455	159	4	365	128
M 4	4.0	0.50	6	475	238	5	400	200	4	320	160
M 5	5.0	0.50	6	380	190	5	320	160	4	255	128
M 6	6.0	0.50	6	320	160	5	265	133	4	210	105
M 8	8.0	0.50	6	240	120	5	200	100	4	160	80
M10	10.0	0.50	6	190	95	5	160	80	4	125	63
M 6	6.0	0.75	6	320	240	5	265	199	4	210	158
M 7	7.0	0.75	6	275	206	5	225	169	4	180	135
M 8	8.0	0.75	6	240	180	5	200	150	4	160	120
M10	10.0	0.75	6	190	143	5	160	120	4	125	94
M 8	8.0	1.00	6	240	240	5	200	200	4	160	160
M 9	9.0	1.00	6	210	210	5	175	175	4	140	140
M10	10.0	1.00	6	190	190	5	160	160	4	125	125
M10	10.0	1.25	6	190	238	5	160	200	4	125	156
M 2.5	2.5	0.35	4	510	179	3	380	133			
M 3	3.0	0.35	4	425	149	3	320	112			
M 3.5	3.5	0.35	4	365	128	3	275	96			
M 4	4.0	0.50	4	320	160	3	240	120			
M 5	5.0	0.50	4	255	128	3	190	95			
M 6	6.0	0.50	4	210	105	3	160	80			
M 8	8.0	0.50	4	160	80	3	120	60			
M10	10.0	0.50	4	125	63	3	95	48			
M 6	6.0	0.75	4	210	158	3	160	120			
M 7	7.0	0.75	4	180	135	3	135	101			
M 8	8.0	0.75	4	160	120	3	120	90			
M10	10.0	0.75	4	125	94	3	95	71			
M 8	8.0	1.00	4	160	160	3	120	120			
M 9	9.0	1.00	4	140	140	3	105	105			
M10	10.0	1.00	4	125	125	3	95	95			
M10	10.0	1.25	4	125	156	3	95	119			

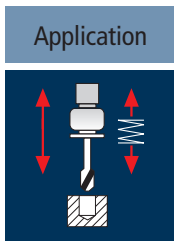
ISO 2
(6H)



MF

Inox
Stainless

261



Material
Stainless steel ferritic/martensitic

Stainless steel ferritic/martensitic

Stainless steel [Cr-Ni/1.4301]

Stainless steel [Cr-Ni/1.4301]

MF	ø [mm]	P [mm]	V_c 1.0 x d	n [min ⁻¹]	v_f [100%]	V_c 1.5 x d	n [min ⁻¹]	v_f [100%]	V_c 2.0 x d	n [min ⁻¹]	v_f [100%]
M12	12.0	0.75	10	265	199	8	210	158	6	160	120
M14	14.0	0.75	10	225	169	8	180	135	6	135	101
M16	16.0	0.75	10	200	150	8	160	120	6	120	90
M12	12.0	1.00	10	265	265	8	210	210	6	160	160
M13	13.0	1.00	10	245	245	8	195	195	6	145	145
M14	14.0	1.00	10	225	225	8	180	180	6	135	135
M16	16.0	1.00	10	200	200	8	160	160	6	120	120
M18	18.0	1.00	10	175	175	8	140	140	6	105	105
M20	20.0	1.00	10	160	160	8	125	125	6	95	95
M12	12.0	1.25	10	265	331	8	210	263	6	160	200
M14	14.0	1.25	10	225	281	8	180	225	6	135	169
M16	16.0	1.25	10	200	250	8	160	200	6	120	150
M12	12.0	1.50	10	265	398	8	210	315	6	160	240
M14	14.0	1.50	10	225	338	8	180	270	6	135	203
M16	16.0	1.50	10	200	300	8	160	240	6	120	180
M18	18.0	1.50	10	175	263	8	140	210	6	105	158
M20	20.0	1.50	10	160	240	8	125	188	6	95	143
M24	24.0	1.50	10	135	203	8	105	158	6	80	120
M12	12.0	0.75	5	135	101	4	105	79	3	80	60
M14	14.0	0.75	5	115	86	4	90	68	3	70	53
M16	16.0	0.75	5	100	75	4	80	60	3	60	45
M12	12.0	1.00	5	135	135	4	105	105	3	80	80
M13	13.0	1.00	5	120	120	4	100	100	3	75	75
M14	14.0	1.00	5	115	115	4	90	90	3	70	70
M16	16.0	1.00	5	100	100	4	80	80	3	60	60
M18	18.0	1.00	5	90	90	4	70	70	3	55	55
M20	20.0	1.00	5	80	80	4	65	65	3	50	50
M12	12.0	1.25	5	135	169	4	105	131	3	80	100
M14	14.0	1.25	5	115	144	4	90	113	3	70	88
M16	16.0	1.25	5	100	125	4	80	100	3	60	75
M12	12.0	1.50	5	135	203	4	105	158	3	80	120
M14	14.0	1.50	5	115	173	4	90	135	3	70	105
M16	16.0	1.50	5	100	150	4	80	120	3	60	90
M18	18.0	1.50	5	90	135	4	70	105	3	55	83
M20	20.0	1.50	5	80	120	4	65	98	3	50	75
M24	24.0	1.50	5	65	98	4	55	83	3	40	60

Material
Stainless steel [Cr-Ni-Mo-.../1.4571]

Stainless steel [Cr-Ni-Mo-.../1.4571]

Heat resistant steel [17-4 PH]

Heat resistant steel [17-4 PH]

MF	ø [mm]	P [mm]	V_c 1.0 x d	n [min ⁻¹]	v_f [100%]	V_c 1.5 x d	n [min ⁻¹]	v_f [100%]	V_c 2.0 x d	n [min ⁻¹]	v_f [100%]
M12	12.0	0.75	6	160	120	5	135	101	4	105	79
M14	14.0	0.75	6	135	101	5	115	86	4	90	68
M16	16.0	0.75	6	120	90	5	100	75	4	80	60
M12	12.0	1.00	6	160	160	5	135	135	4	105	105
M13	13.0	1.00	6	145	145	5	120	120	4	100	100
M14	14.0	1.00	6	135	135	5	115	115	4	90	90
M16	16.0	1.00	6	120	120	5	100	100	4	80	80
M18	18.0	1.00	6	105	105	5	90	90	4	70	70
M20	20.0	1.00	6	95	95	5	80	80	4	65	65
M12	12.0	1.25	6	160	200	5	135	169	4	105	131
M14	14.0	1.25	6	135	169	5	115	144	4	90	113
M16	16.0	1.25	6	120	150	5	100	125	4	80	100
M12	12.0	1.50	6	160	240	5	135	203	4	105	158
M14	14.0	1.50	6	135	203	5	115	173	4	90	135
M16	16.0	1.50	6	120	180	5	100	150	4	80	120
M18	18.0	1.50	6	105	158	5	90	135	4	70	105
M20	20.0	1.50	6	95	143	5	80	120	4	65	98
M24	24.0	1.50	6	80	120	5	65	98	4	55	83
M12	12.0	0.75	4	105	79	3	80	60			
M14	14.0	0.75	4	90	68	3	70	53			
M16	16.0	0.75	4	80	60	3	60	45			
M12	12.0	1.00	4	105	105	3	80	80			
M13	13.0	1.00	4	100	100	3	75	75			
M14	14.0	1.00	4	90	90	3	70	70			
M16	16.0	1.00	4	80	80	3	60	60			
M18	18.0	1.00	4	70	70	3	55	55			
M20	20.0	1.00	4	65	65	3	50	50			
M12	12.0	1.25	4	105	131	3	80	100			
M14	14.0	1.25	4	90	113	3	70	88			
M16	16.0	1.25	4	80	100	3	60	75			
M12	12.0	1.50	4	105	158	3	80	120			
M14	14.0	1.50	4	90	135	3	70	105			
M16	16.0	1.50	4	80	120	3	60	90			
M18	18.0	1.50	4	70	105	3	55	83			
M20	20.0	1.50	4	65	98	3	50	75			
M24	24.0	1.50	4	55	83	3	40	60			

Taps x-tap

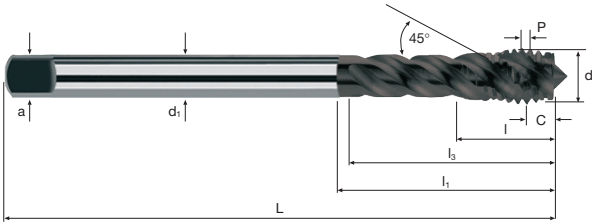


MF

ISO 2
(6H)

HSS
PM/F

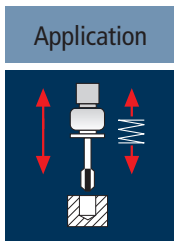
Form C



MF

Inox
Stainless

											TRIBO
											ET1261
Example: Order-N°.	Article-N°.		α-Code								
	ET1261		.070								
Ø Code	d	P	L	l	l ₁	l ₃	d ₁	a			
.070	M12	0.75	100	11	39	37	9.0	7.0	4	11.40 *	●
.072	M14	0.75	100	11	39	37	11.0	9.0	4	13.40 *	●
.074	M16	0.75	100	12	39	37	12.0	9.0	4	15.40 *	●
.094	M12	1.00	100	11	39	37	9.0	7.0	4	11.10	●
.095	M13	1.00	100	11	39	37	11.0	9.0	4	12.10	●
.096	M14	1.00	100	11	39	37	11.0	9.0	4	13.10	●
.097	M15	1.00	100	12	39	37	12.0	9.0	4	14.10	●
.098	M16	1.00	100	12	39	37	12.0	9.0	4	15.10	●
.099	M17	1.00	100	12	39	37	12.0	9.0	4	16.10	●
.100	M18	1.00	110	13	50	48	14.0	11.0	4	17.10	●
.102	M20	1.00	125	14	65	63	16.0	12.0	4	19.10	●
.164	M12	1.25	100	15	39	37	9.0	7.0	4	10.90	●
.166	M14	1.25	100	15	39	37	11.0	9.0	4	12.90	●
.168	M16	1.25	100	15	39	37	12.0	9.0	4	14.90	●
.176	M12	1.50	100	15	39	37	9.0	7.0	4	10.70 *	●
.178	M14	1.50	100	15	39	37	11.0	9.0	4	12.70 *	●
.180	M16	1.50	100	15	39	37	12.0	9.0	4	14.70 *	●
.182	M18	1.50	110	17	50	48	14.0	11.0	4	16.70 *	●
.184	M20	1.50	125	18	65	63	16.0	12.0	4	18.70 *	●
.186	M22	1.50	125	18	65	63	18.0	14.5	5	20.70 *	●
.188	M24	1.50	140	20	72	70	18.0	14.5	5	22.70 *	●
* The given dimension is out of norm											



Material
Cast iron GG

MF	ø	P	V _c	n	v _f	V _c	n	v _f	V _c	n	v _f
	[mm]	[mm]	1.0 x d	[min ⁻¹]	[100%]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	28	3565	1248	24	3055	1069	20	2545	891
M 3	3.0	0.35	28	2970	1040	24	2545	891	20	2120	742
M 3.5	3.5	0.35	28	2545	891	24	2185	765	20	1820	637
M 4	4.0	0.50	28	2230	1115	24	1910	955	20	1590	795
M 5	5.0	0.50	28	1785	893	24	1530	765	20	1275	638
M 6	6.0	0.50	28	1485	743	24	1275	638	20	1060	530
M 8	8.0	0.50	28	1115	558	24	955	478	20	795	398
M10	10.0	0.50	28	890	445	24	765	383	20	635	318
M 6	6.0	0.75	28	1485	1114	24	1275	956	20	1060	795

Cast iron GG

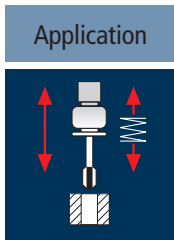
M 7	7.0	0.75	28	1275	956	24	1090	818	20	910	683
M 8	8.0	0.75	28	1115	836	24	955	716	20	795	596
M10	10.0	0.75	28	890	668	24	765	574	20	635	476
M 8	8.0	1.00	28	1115	1115	24	955	955	20	795	795
M 9	9.0	1.00	28	990	990	24	850	850	20	705	705
M10	10.0	1.00	28	890	890	24	765	765	20	635	635
M10	10.0	1.25	28	890	1113	24	765	956	20	635	794

Cast iron GGG

M 2.5	2.5	0.35	20	2545	891	18	2290	802	15	1910	669
M 3	3.0	0.35	20	2120	742	18	1910	669	15	1590	557
M 3.5	3.5	0.35	20	1820	637	18	1635	572	15	1365	478
M 4	4.0	0.50	20	1590	795	18	1430	715	15	1195	598
M 5	5.0	0.50	20	1275	638	18	1145	573	15	955	478
M 6	6.0	0.50	20	1060	530	18	955	478	15	795	398
M 8	8.0	0.50	20	795	398	18	715	358	15	595	298
M10	10.0	0.50	20	635	318	18	575	288	15	475	238
M 6	6.0	0.75	20	1060	795	18	955	716	15	795	596

Cast iron GGG

M 7	7.0	0.75	20	910	683	18	820	615	15	680	510
M 8	8.0	0.75	20	795	596	18	715	536	15	595	446
M10	10.0	0.75	20	635	476	18	575	431	15	475	356
M 8	8.0	1.00	20	795	795	18	715	715	15	595	595
M 9	9.0	1.00	20	705	705	18	635	635	15	530	530
M10	10.0	1.00	20	635	635	18	575	575	15	475	475
M10	10.0	1.25	20	635	794	18	575	719	15	475	594



Material
Cast iron GG

MF	ø	P	V _c	n	v _f	V _c	n	v _f	V _c	n	v _f
	[mm]	[mm]	1.5 x d	[min ⁻¹]	[100%]	2.0 x d	[min ⁻¹]	[100%]	3.0 x d	[min ⁻¹]	[100%]
M 2.5	2.5	0.35	30	3820	1337	28	3565	1248	25	3185	1115
M 3	3.0	0.35	30	3185	1115	28	2970	1040	25	2655	929
M 3.5	3.5	0.35	30	2730	955	28	2545	891	25	2275	796
M 4	4.0	0.50	30	2385	1193	28	2230	1115	25	1990	995
M 5	5.0	0.50	30	1910	955	28	1785	893	25	1590	795
M 6	6.0	0.50	30	1590	795	28	1485	743	25	1325	663
M 8	8.0	0.50	30	1195	598	28	1115	558	25	995	498
M10	10.0	0.50	30	955	478	28	890	445	25	795	398
M 6	6.0	0.75	30	1590	1193	28	1485	1114	25	1325	994

Cast iron GG

M 7	7.0	0.75	30	1365	1024	28	1275	956	25	1135	851
M 8	8.0	0.75	30	1195	896	28	1115	836	25	995	746
M10	10.0	0.75	30	955	716	28	890	668	25	795	596
M 8	8.0	1.00	30	1195	1195	28	1115	1115	25	995	995
M 9	9.0	1.00	30	1060	1060	28	990	990	25	885	885
M10	10.0	1.00	30	955	955	28	890	890	25	795	795
M10	10.0	1.25	30	955	1194	28	890	1113	25	795	994

Cast iron GGG

M 2.5	2.5	0.35	25	3185	1115	22	2800	980	20	2545	891
M 3	3.0	0.35	25	2655	929	22	2335	817	20	2120	742
M 3.5	3.5	0.35	25	2275	796	22	2000	700	20	1820	637
M 4	4.0	0.50	25	1990	995	22	1750	875	20	1590	795
M 5	5.0	0.50	25	1590	795	22	1400	700	20	1275	638
M 6	6.0	0.50	25	1325	663	22	1165	583	20	1060	530
M 8	8.0	0.50	25	995	498	22	875	438	20	795	398
M10	10.0	0.50	25	795	398	22	700	350	20	635	318
M 6	6.0	0.75	25	1325	994	22	1165	874	20	1060	795

Cast iron GGG

M 7	7.0	0.75	25	1135	851	22	1000	750	20	910	683
M 8	8.0	0.75	25	995	746	22	875	656	20	795	596
M10	10.0	0.75	25	795	596	22	700	525	20	635	476
M 8	8.0	1.00	25	995	995	22	875	875	20	795	795
M 9	9.0	1.00	25	885	885	22	780	780	20	705	705
M10	10.0	1.00	25	795	795	22	700	700	20	635	635
M10	10.0	1.25	25	795	994	22	700	875	20	635	794

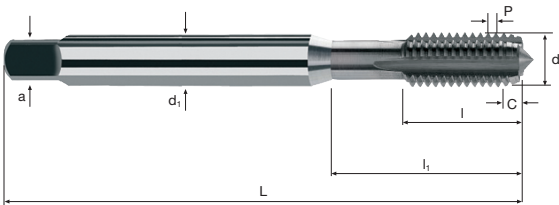
Taps



MF

ISO 2
(6H)

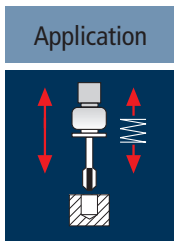
HSS
PM/F



MF

GG(G)

										TiCN	
										EH1270	
Example: Order-Nº.											
Article-Nº. α-Code											
EH1270 .029											
Ø Code	d	P	L	l	li	d1	a				
.029	M 2.5	0.35	50	9	—	2.8	2.1	3	2.15		●
.031	M 3	0.35	56	12	18	3.5	2.7	3	2.65		●
.032	M 3.5	0.35	56	12	20	4.0	3.0	3	3.15		●
.046	M 4	0.50	63	13	21	4.5	3.4	3	3.50		●
.048	M 5	0.50	70	15	25	6.0	4.9	3	4.50		●
.050	M 6	0.50	80	17	30	6.0	4.9	4	5.50		●
.052	M 8	0.50	90	20	35	8.0	6.2	4	7.50		●
.054	M10	0.50	100	22	39	10.0	8.0	4	9.50		●
.064	M 6	0.75	80	17	30	6.0	4.9	4	5.20		●
.065	M 7	0.75	80	17	30	7.0	5.5	4	6.20		●
.066	M 8	0.75	90	20	35	8.0	6.2	4	7.20		●
.068	M10	0.75	100	22	39	10.0	8.0	4	9.20		●
.090	M 8	1.00	90	20	35	8.0	6.2	4	7.00		●
.091	M 9	1.00	90	20	35	9.0	7.0	4	8.00		●
.092	M10	1.00	100	22	39	10.0	8.0	4	9.00		●
.162	M10	1.25	100	22	39	10.0	8.0	4	8.80		●
For larger dimensions see article no. EH1271, page 267											



Material
Cast iron GG

MF	ø [mm]	P [mm]	V_c 1.0 x d	n [min ⁻¹]	v_f [100%]	V_c 1.5 x d	n [min ⁻¹]	v_f [100%]	V_c 2.0 x d	n [min ⁻¹]	v_f [100%]
M12	12.0	0.75	28	745	559	24	635	476	20	530	398
M14	14.0	0.75	28	635	476	24	545	409	20	455	341
M16	16.0	0.75	28	555	416	24	475	356	20	400	300
M12	12.0	1.00	28	745	745	24	635	635	20	530	530
M13	13.0	1.00	28	685	685	24	590	590	20	490	490
M14	14.0	1.00	28	635	635	24	545	545	20	455	455
M16	16.0	1.00	28	555	555	24	475	475	20	400	400
M18	18.0	1.00	28	495	495	24	425	425	20	355	355
M20	20.0	1.00	28	445	445	24	380	380	20	320	320

Cast iron GG

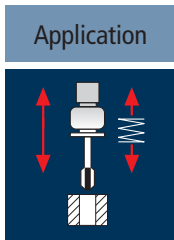
M12	12.0	1.25	28	745	931	24	635	794	20	530	663
M14	14.0	1.25	28	635	794	24	545	681	20	455	569
M16	16.0	1.25	28	555	694	24	475	594	20	400	500
M12	12.0	1.50	28	745	1118	24	635	953	20	530	795
M14	14.0	1.50	28	635	953	24	545	818	20	455	683
M16	16.0	1.50	28	555	833	24	475	713	20	400	600
M18	18.0	1.50	28	495	743	24	425	638	20	355	533
M20	20.0	1.50	28	445	668	24	380	570	20	320	480
M24	24.0	1.50	28	370	555	24	320	480	20	265	398

Cast iron GGG

M12	12.0	0.75	20	530	398	18	475	356	15	400	300
M14	14.0	0.75	20	455	341	18	410	308	15	340	255
M16	16.0	0.75	20	400	300	18	360	270	15	300	225
M12	12.0	1.00	20	530	530	18	475	475	15	400	400
M13	13.0	1.00	20	490	490	18	440	440	15	365	365
M14	14.0	1.00	20	455	455	18	410	410	15	340	340
M16	16.0	1.00	20	400	400	18	360	360	15	300	300
M18	18.0	1.00	20	355	355	18	320	320	15	265	265
M20	20.0	1.00	20	320	320	18	285	285	15	240	240

Cast iron GGG

M12	12.0	1.25	20	530	663	18	475	594	15	400	500
M14	14.0	1.25	20	455	569	18	410	513	15	340	425
M16	16.0	1.25	20	400	500	18	360	450	15	300	375
M12	12.0	1.50	20	530	795	18	475	713	15	400	600
M14	14.0	1.50	20	455	683	18	410	615	15	340	510
M16	16.0	1.50	20	400	600	18	360	540	15	300	450
M18	18.0	1.50	20	355	533	18	320	480	15	265	398
M20	20.0	1.50	20	320	480	18	285	428	15	240	360
M24	24.0	1.50	20	265	398	18	240	360	15	200	300



Cast iron GG

MF	ø [mm]	P [mm]	V_c 1.5 x d	n [min ⁻¹]	v_f [100%]	V_c 2.0 x d	n [min ⁻¹]	v_f [100%]	V_c 3.0 x d	n [min ⁻¹]	v_f [100%]
M12	12.0	0.75	30	795	596	28	745	559	25	665	499
M14	14.0	0.75	30	680	510	28	635	476	25	570	428
M16	16.0	0.75	30	595	446	28	555	416	25	495	371
M12	12.0	1.00	30	795	795	28	745	745	25	665	665
M13	13.0	1.00	30	735	735	28	685	685	25	610	610
M14	14.0	1.00	30	680	680	28	635	635	25	570	570
M16	16.0	1.00	30	595	595	28	555	555	25	495	495
M18	18.0	1.00	30	530	530	28	495	495	25	440	440
M20	20.0	1.00	30	475	475	28	445	445	25	400	400

Cast iron GG

M12	12.0	1.25	30	795	994	28	745	931	25	665	831
M14	14.0	1.25	30	680	850	28	635	794	25	570	713
M16	16.0	1.25	30	595	744	28	555	694	25	495	619
M12	12.0	1.50	30	795	1193	28	745	1118	25	665	998
M14	14.0	1.50	30	680	1020	28	635	953	25	570	855
M16	16.0	1.50	30	595	893	28	555	833	25	495	743
M18	18.0	1.50	30	530	795	28	495	743	25	440	660
M20	20.0	1.50	30	475	713	28	445	668	25	400	600
M24	24.0	1.50	30	400	600	28	370	555	25	330	495

Cast iron GGG

M12	12.0	0.75	25	665	499	22	585	439	20	530	398
M14	14.0	0.75	25	570	428	22	500	375	20	455	341
M16	16.0	0.75	25	495	371	22	440	330	20	400	300
M12	12.0	1.00	25	665	665	22	585	585	20	530	530
M13	13.0	1.00	25	610	610	22	540	540	20	490	490
M14	14.0	1.00	25	570	570	22	500	500	20	455	455
M16	16.0	1.00	25	495	495	22	440	440	20	400	400
M18	18.0	1.00	25	440	440	22	390	390	20	355	355
M20	20.0	1.00	25	400	400	22	350	350	20	320	320

Cast iron GGG

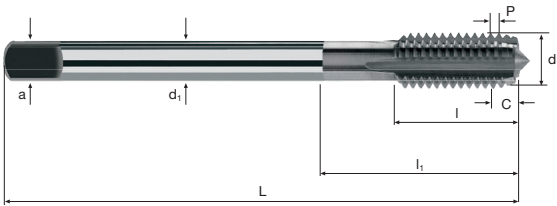
M12	12.0	1.25	25	665	831	22	585	731	20	530	663
M14	14.0	1.25	25	570	713	22	500	625	20	455	569
M16	16.0	1.25	25	495	619	22	440	550	20	400	500
M12	12.0	1.50	25	665	998	22	585	878	20	530	795
M14	14.0	1.50	25	570	855	22	500	750	20	455	683
M16	16.0	1.50	25	495	743	22	440	660	20	400	600
M18	18.0	1.50	25	440	660	22	390	585	20	355	533
M20	20.0	1.50	25	400	600	22	350	525	20	320	480
M24	24.0	1.50	25	330	495	22	290	435	20	265	398



MF

ISO 2
(6H)

HSS
PM/F

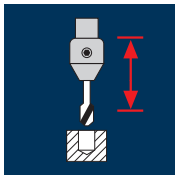


MF

GG(G)

										TiCN	
										EH1271	
Ø Code	d	P	L	l	l ₁	d ₁	a				
.070	M12	0.75	100	18	39	9.0	7.0	4	11.30		●
.072	M14	0.75	100	18	39	11.0	9.0	4	13.30		●
.074	M16	0.75	100	18	39	12.0	9.0	4	15.30		●
.094	M12	1.00	100	18	39	9.0	7.0	4	11.00		●
.095	M13	1.00	100	18	39	11.0	9.0	4	12.00		●
.096	M14	1.00	100	18	39	11.0	9.0	4	13.00		●
.097	M15	1.00	100	18	39	12.0	9.0	4	14.00		●
.098	M16	1.00	100	18	39	12.0	9.0	4	15.00		●
.099	M17	1.00	100	18	39	12.0	9.0	4	16.00		●
.100	M18	1.00	110	20	45	14.0	11.0	4	17.00		●
.102	M20	1.00	125	20	50	16.0	12.0	4	19.00		●
.164	M12	1.25	100	22	39	9.0	7.0	4	10.80		●
.166	M14	1.25	100	22	39	11.0	9.0	4	12.80		●
.168	M16	1.25	100	22	39	12.0	9.0	4	14.80		●
.176	M12	1.50	100	22	39	9.0	7.0	4	10.50		●
.178	M14	1.50	100	22	39	11.0	9.0	4	12.50		●
.180	M16	1.50	100	22	39	12.0	9.0	4	14.50		●
.182	M18	1.50	110	25	45	14.0	11.0	4	16.50		●
.184	M20	1.50	125	26	50	16.0	12.0	4	18.50		●
.186	M22	1.50	125	26	50	18.0	14.5	5	20.50		●
.188	M24	1.50	140	27	52	18.0	14.5	5	22.50		●

Application



Material

Steel
500 - 850 N/mm²

Steel
500 - 850 N/mm²

Steel
850 - 1100 N/mm²

Steel
850 - 1100 N/mm²

MF	ø [mm]	P [mm]	V _c n 1.0 x d [min ⁻¹]		V _c n 1.5 x d [min ⁻¹]		V _c n 2.0 x d [min ⁻¹]	
M 3	3.0	0.35	22	2335	20	2120	12	1275
M 4	4.0	0.50	22	1750	20	1590	12	955
M 5	5.0	0.50	22	1400	20	1275	12	765
M 6	6.0	0.50	22	1165	20	1060	12	635
M 6	6.0	0.75	22	1165	20	1060	12	635
M 8	8.0	0.75	22	875	20	795	12	475
M10	10.0	0.75	22	700	20	635	12	380
M 8	8.0	1.00	22	875	20	795	12	475
M10	10.0	1.00	22	700	20	635	12	380
M12	12.0	1.00	22	585	20	530	12	320
M14	14.0	1.00	22	500	20	455	12	275
M16	16.0	1.00	22	440	20	400	12	240
M10	10.0	1.25	22	700	20	635	12	380
M12	12.0	1.25	22	585	20	530	12	320
M12	12.0	1.50	22	585	20	530	12	320
M14	14.0	1.50	22	500	20	455	12	275
M16	16.0	1.50	22	440	20	400	12	240
M20	20.0	1.50	22	350	20	320	12	190
M 3	3.0	0.35	18	1910	12	1275	8	850
M 4	4.0	0.50	18	1430	12	955	8	635
M 5	5.0	0.50	18	1145	12	765	8	510
M 6	6.0	0.50	18	955	12	635	8	425
M 6	6.0	0.75	18	955	12	635	8	425
M 8	8.0	0.75	18	715	12	475	8	320
M10	10.0	0.75	18	575	12	380	8	255
M 8	8.0	1.00	18	715	12	475	8	320
M10	10.0	1.00	18	575	12	380	8	255
M12	12.0	1.00	18	475	12	320	8	210
M14	14.0	1.00	18	410	12	275	8	180
M16	16.0	1.00	18	360	12	240	8	160
M10	10.0	1.25	18	575	12	380	8	255
M12	12.0	1.25	18	475	12	320	8	210
M12	12.0	1.50	18	475	12	320	8	210
M14	14.0	1.50	18	410	12	275	8	180
M16	16.0	1.50	18	360	12	240	8	160
M20	20.0	1.50	18	285	12	190	8	125

Material

Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni/1.4301]



Wrought aluminium
alloys Si < 6%
hardened

Wrought aluminium
alloys Si < 6%
hardened

MF	ø [mm]	P [mm]	V _c n 1.0 x d [min ⁻¹]		V _c n 1.5 x d [min ⁻¹]		V _c n 2.0 x d [min ⁻¹]	
M 3	3.0	0.35	4	425	3	320	2	210
M 4	4.0	0.50	4	320	3	240	2	160
M 5	5.0	0.50	4	255	3	190	2	125
M 6	6.0	0.50	4	210	3	160	2	105
M 6	6.0	0.75	4	210	3	160	2	105
M 8	8.0	0.75	4	160	3	120	2	80
M10	10.0	0.75	4	125	3	95	2	65
M 8	8.0	1.00	4	160	3	120	2	80
M10	10.0	1.00	4	125	3	95	2	65
M12	12.0	1.00	4	105	3	80	2	55
M14	14.0	1.00	4	90	3	70	2	45
M16	16.0	1.00	4	80	3	60	2	40
M10	10.0	1.25	4	125	3	95	2	65
M12	12.0	1.25	4	105	3	80	2	55
M12	12.0	1.50	4	105	3	80	2	55
M14	14.0	1.50	4	90	3	70	2	45
M16	16.0	1.50	4	80	3	60	2	40
M20	20.0	1.50	4	65	3	50	2	30
M 3	3.0	0.35	22	2335	20	2120	12	1275
M 4	4.0	0.50	22	1750	20	1590	12	955
M 5	5.0	0.50	22	1400	20	1275	12	765
M 6	6.0	0.50	22	1165	20	1060	12	635
M 6	6.0	0.75	22	1165	20	1060	12	635
M 8	8.0	0.75	22	875	20	795	12	475
M10	10.0	0.75	22	700	20	635	12	380
M 8	8.0	1.00	22	875	20	795	12	475
M10	10.0	1.00	22	700	20	635	12	380
M12	12.0	1.00	22	585	20	530	12	320
M14	14.0	1.00	22	500	20	455	12	275
M16	16.0	1.00	22	440	20	400	12	240
M10	10.0	1.25	22	700	20	635	12	380
M12	12.0	1.25	22	585	20	530	12	320
M12	12.0	1.50	22	585	20	530	12	320
M14	14.0	1.50	22	500	20	455	12	275
M16	16.0	1.50	22	440	20	400	12	240
M20	20.0	1.50	22	350	20	320	12	190

Taps polytap-R

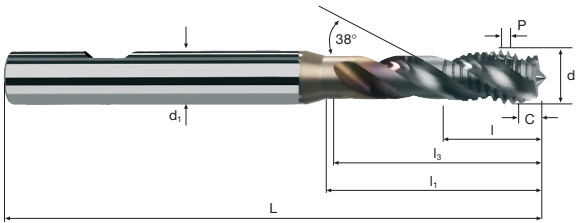


MF

ISO 2
(6H)

HSS
PM/F

Form C



MF

Rm
< 850

Rm
850-1100

Inox
Stainless

GG(G)
Aluminium

										TiCN	
										EH1229	
Ø Code	d	P	L	l	l1	l3	d1 h6				
.031	M 3	0.35	63	5	18	16	6	3	2.65		●
.046	M 4	0.50	66	7	21	19	6	3	3.50		●
.048	M 5	0.50	70	8	25	23	6	3	4.50		●
.050	M 6	0.50	80	10	30	28	6	3	5.50		●
.064	M 6	0.75	80	10	30	28	6	3	5.20		●
.066	M 8	0.75	90	13	35	33	8	3	7.20		●
.068	M10	0.75	100	15	39	37	10	3	9.20		●
.090	M 8	1.00	90	13	35	37	8	3	7.00		●
.092	M10	1.00	100	15	39	37	10	3	9.00		●
.094	M12	1.00	110	11	39	37	12	3	11.00		●
.096	M14	1.00	110	11	46	44	16	4	13.00		●
.098	M16	1.00	110	12	50	48	16	4	15.00		●
.162	M10	1.25	100	15	39	37	10	3	8.80		●
.164	M12	1.25	110	15	39	37	12	3	10.80		●
.176	M12	1.50	110	15	39	37	12	3	10.50		●
.178	M14	1.50	110	15	46	44	16	4	12.50		●
.180	M16	1.50	110	15	50	48	16	4	14.50		●
.184	M20	1.50	140	20	64	62	16	4	18.50		●